

Work Order ID 105985

105985

Page 1

August-28-13 11:51:45 AM

Item ID: D3566-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Fwd

Start Date: 8/28/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/28/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-08-29

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3566

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

20 0 Jm13-09-10

FLOW CNC Waterjet

1-Cut as per Dwg D3566 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

20 0 Jm13-09-10

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

DAS
27
9-89

20

Quality Control

13911

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
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		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
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Work Order ID 105985

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FP-00d 0.00

130

Packaging

Memo

0.00

Packaging

120 13/09/11

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/9/11

13-09-11

NCR: Yes / No

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Equip/Tooling									
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Material									
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Unapproved									

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Landing Gear	General	Other
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Picklist Print

August-28-13 11:51:45 AM

Page 1

Work Order ID: 105985
Parent Item: D3566-13
Parent Item Name: Gasket Fwd

Start Date: 8/28/13
Start Qty: 12.00

Required Date: 8/28/13
Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	966.2700	0.195	26000004 3.0		Jm13-09-10	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT052		966.27							
				123761		153							
				125290		69.4							
				M125904		39.87							
				M126546		704				26546			

NCR: Yes / No

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DART AEROSPACE LTD		Work Order: 105985
Description: Gasket		Part Number: D3566-13
Inspection Dwg: D3566	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

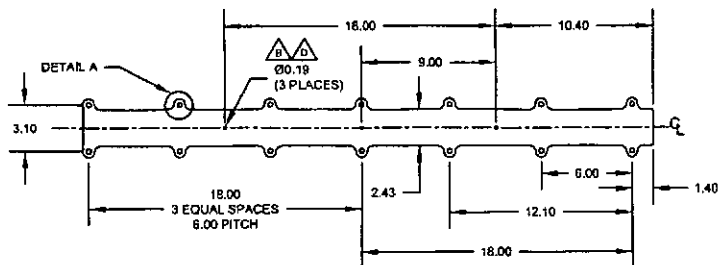
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00	+/-0.030	7.00"	-		U	JKMO1
3.50	+/-0.030	3.50"	-		U	
2.43	+/-0.030	2.43"	-		U	
3.10	+/-0.030	3.10"	-		U	
0.30	+/-0.030	0.30"	-		U	
0.30	+/-0.030	0.30"	-		U	
0.063	+/-0.010	0.060"	-		U	
Ø0.188	+0.005/-0.001	0.188"	-		U	

DAS

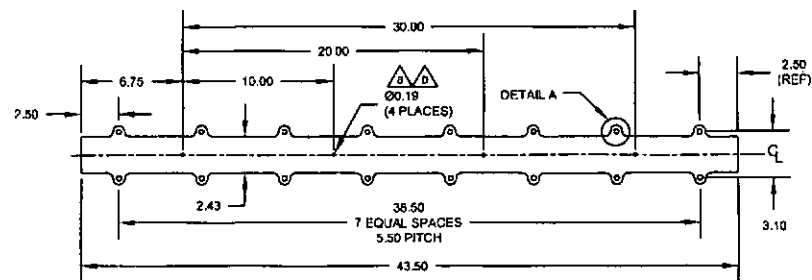
Measured by: Jm	Audited by: 27 9-89	Prototype Approval:	N/A
Date: 13-09-10	Date: 13 9 11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.20	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	08.09.04	Dwg Rev updated	KJ/DD	

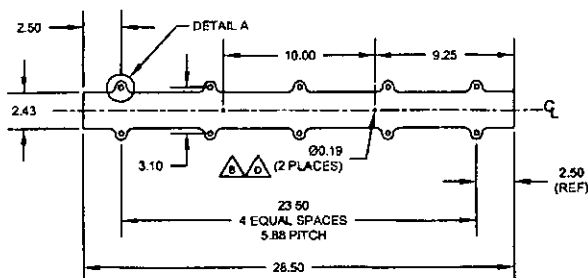
8 7 6 5 4 3 2 1



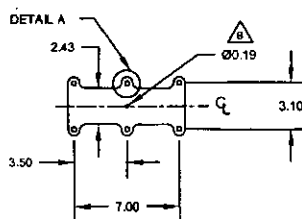
D3566-1 GASKET



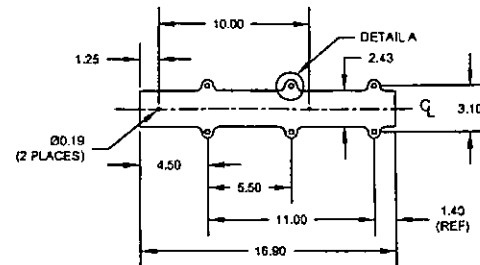
D3566-5 GASKET



D3566-7 GASKET



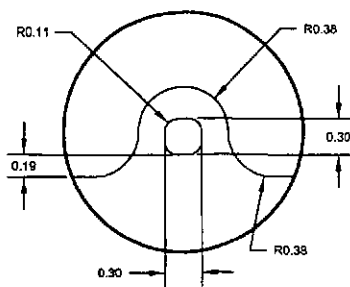
D3566-13 GASKET



D3566-15 GASKET

RELEASED

07.08.21



**DETAIL A
SCALE 1:1**

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.38 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

C	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES): A8: UPDATE NOTES: A8, B2: ADD D3566-15: A5: INCREASE SIZE OF DETAIL A:		CB	07.08.21
B	ADD DRAIN HOLES		PH	07.04.17
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB			
CHECKED	PH		DRAWING NO.	REV. C
MFG. APPR.	PH		D3566	SHEET 1 OF 1
APPROVED	PH		TITLE	SCALE
DE APPR.	PH		GASKET	1
DATE	07.08.21		COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY AND IS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

105985 MLJ
13-08-29

